

Work Order ID 119882

May-28-14 2:52:26 PM

119882

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Item ID: D5062-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Bracket Assembly

Start Date: 5/28/14

Start Qty: 20.00

20

Cust Item ID:

Required Date: 6/05/14

Req'd Qty: 20.00

20

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

130

Bend as per dwg and transfer drill
holes to size as per dwg

0.00

130

Brake NC

Memo

0.00

Brake NC

140

QC5- Inspect part completeness to step on W/O

0.00

140

QC

Memo

0.00

Quality Control

SMP
14/6/13DAS
30
9-89

4

DAS
36
9-8914/06/03
14/06/03DAS
27
9-89
14/6/13

4

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Item ID: D5062-041 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Bracket Assembly
 Start Date: 5/28/14 Start Qty: 20.00 *20* Cust Item ID:
 Required Date: 6/05/14 Req'd Qty: 20.00 *20* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Chemical Conversion Coat per QSI005 4.1	0.00							
150						4			
Hand Finish	Memo	0.00							
Hand Finishing									
160	QC7-Inspect Chemical Conversion Coat	0.00							
160						4X			
QC	Memo	0.00							14/06/03
Quality Control									
170		0.00							
170						4X			
Small Fab	Memo	0.00							14/06/03
Small Fab	INSTALL RIVET AS PER DWG								

DAS
36
9-89

DAS
36
9-89

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Item ID: D5062-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Bracket Assembly

Start Date: 5/28/14

Start Qty: 20.00

20

Cust Item ID:

Required Date: 6/05/14

Req'd Qty: 20.00

20

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start *NR1*

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop *NR2*

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC5- Inspect part completeness to step on W/O

0.00

180

QC

Memo

0.00

DAS
30
9-89

Quality Control

14/06/03

190

0.00

190

SprayPaint

Memo

0.00

Spray Painting

PRIME AS PER DWG AND PER QSI 005

A/R PRIMER IAW MIL-P-23377J TYPE 1 CLASS N

BATCH: 127406

DAS
27
3-38

200

QC14- Inspect Spray Paint

0.00

2000

QC

Memo

0.00

Quality Control

14/6/4

4

14/06/04

4

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Item ID: D5062-041 Accept *N9000040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Bracket Assembly
 Start Date: 5/28/14 Start Qty: 20.00 *20* Cust Item ID:
 Required Date: 6/05/14 Req'd Qty: 20.00 *20* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210	Identify as per dwg & Stock Location: <u>ST</u>	0.00							
210									
Packaging	Memo	0.00				4X	DAS 28 9-89		JUN 04 2014
Packaging									
220	QC21- Final Inspection - Work Order Release	0.00							
220									
QC	Memo	0.00							
Quality Control									

MW 14-06-04

ME
14-6-4

Picklist Print

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Work Order ID: 119882

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Parent Item: D5062-041

D5062-041

Parent Item Name: Bracket Assembly

Start Date: 5/28/14

Required Date: 6/05/14

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP REV:A 14.02.11 NEW ISSUE DD VERF:JLM IPP
REV:B 14.05.28 AS PER DWG REV.A DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M606-T6S.080		Purchased		No			sf	381.5600		5			
<p>*M6061T6S 080*</p> <p>5061-T6 .080 Sheet</p>													

**

mm 17/06/01

Location	Loc Qty	Loc Code
MAT021	381.56	
m126309	130.52	
m126350	13.34	
m128903	237.7	

MS20470AD4-5 Purchased No

MS20470AD4-5

RIVET, UNIVERSAL HEAD

Each 3,255.000

80

**

17/06/03

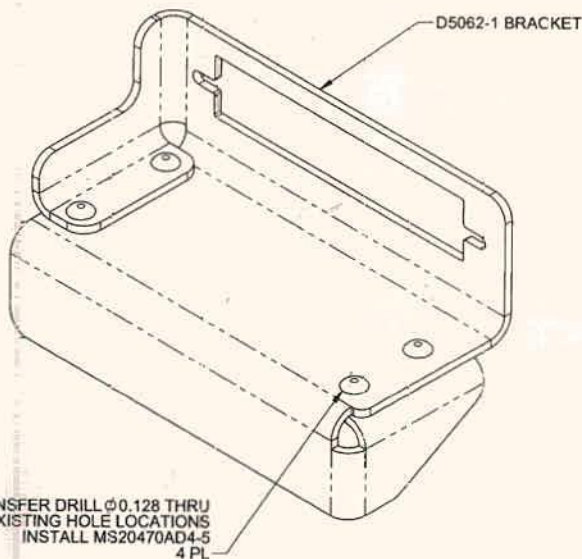
DAS
36
9-89

Location	Loc Qty	Loc Code
ST336	3255	
m126926	339	
m128401	1653	
m128813	1263	

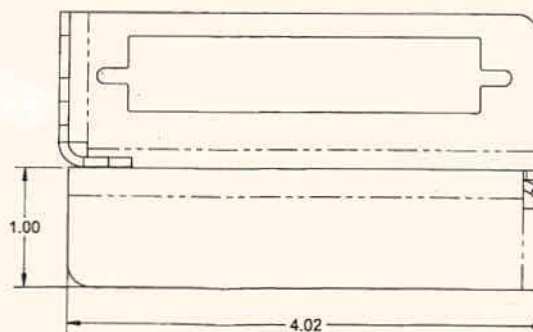
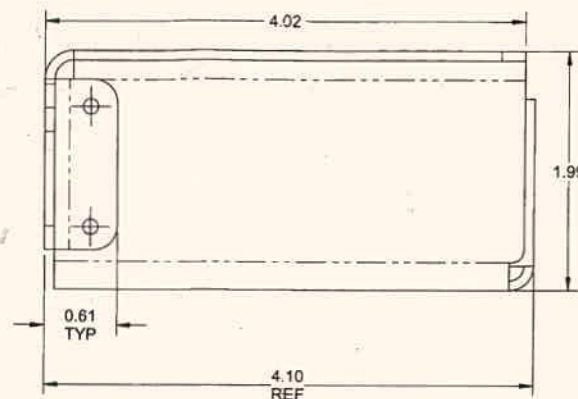
16

ITEM	QTY	P/N	DESCRIPTION
	X	D5062-041	BRACKET ASSY
1	1	D5062-1	BRACKET
2	4	MS20470AD4-5	RIVET, PANHEAD

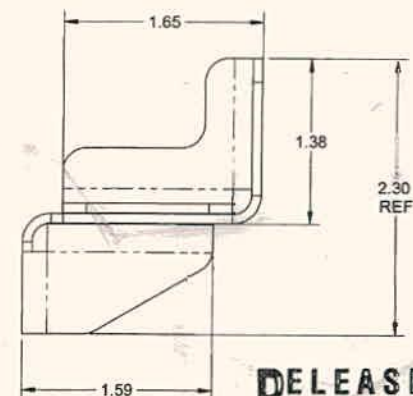
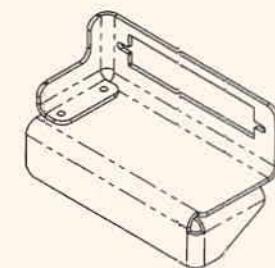
w/b 119882



D5062-041 BRACKET ASSY



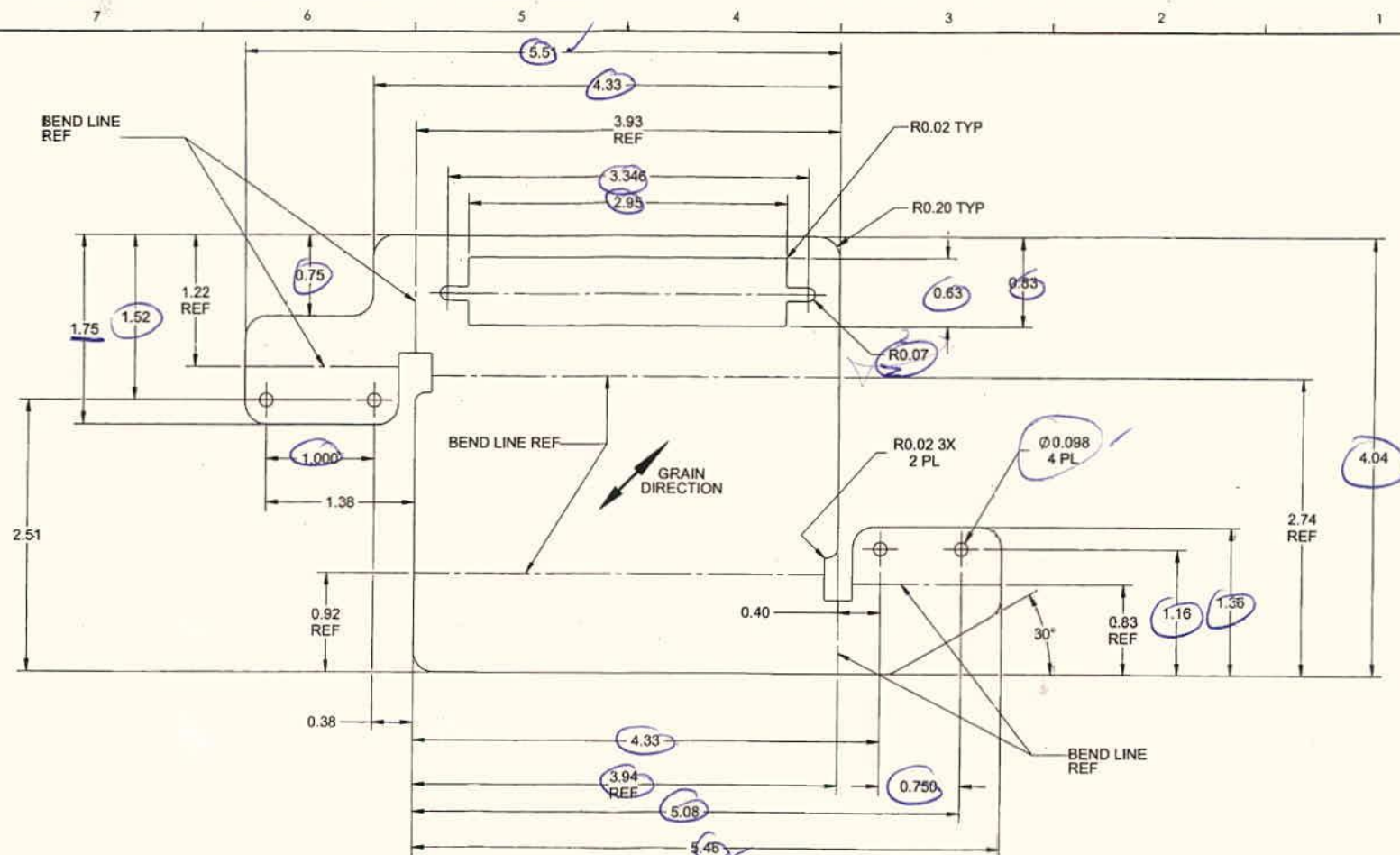
D5062-1 BRACKET
MAKE FROM D5062-1F



RELEASED
2014-05-28

- NOTES:**
- 1) MATERIAL: MAKE FROM D5062-1F
 - 2) FINISH: D5062-1: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1, D5062-041: PRIME IAW MIL-P-23377J TYPE I CLASS N; 1-2 MIL MAX, AS PER QSI 005.
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D5062-041" PER QSI 044 6.1
 - 7) WEIGHT: 0.13lbs

A	NEW ISSUE	DB	14.02.10
REV.	DESCRIPTION	BY	DATE
DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED	DW	DRAWING NO.	REV. A
MFG. APPR.	DD	D5062	SHEET 1 OF 2
APPROVED	MP	TITLE	SCALE
DE APPR.	DS	BRACKET	NTS
DATE	14.02.10	COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



D5062-1F FLAT PATTERN

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.080)
- 2) FINISH: D5062-1F: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.13 lbs
- 8) ALL NON-DIMENSIONED FEATURES CONTROLLED BY CAD FILE "D5062-1F-A.DXF"

RELEASED
2014-05-28

DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED	DW	DRAWING NO.	REV. A
MFG. APPR.	DD	D5062	SHEET 2 OF 2
APPROVED	MP	TITLE	SCALE
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